

CLAIMS

1. A method for making a polymeric part having an anti-graffiti property, the method comprising:

formulating a first mixture of a polymer and a hydrocarbon mixture;

forming a substantially planar sheet of the first mixture;

formulating a second mixture of a mineral oil and a wax;

coating a surface of a forming mold with the second mixture of a mineral oil and a wax; and

thermoforming the substantially planar sheet to form the polymeric part using the forming mold coated with the second mixture of mineral oil and wax.

2. The method of claim 1 wherein formulating a first mixture further includes mixing a mineral oil and a wax to form a hydrocarbon mixture.

3. The method of claim 1 wherein formulating the second mixture includes mixing 50% mineral oil and 50% wax by weight to form the second mixture.

4. The method of claim 1 wherein the hydrocarbon mixture has a melting point between 25-65°C.

5. The method of claim 4 wherein the hydrocarbon mixture has a melting point between 35-50°C.

6. The method of claim 1 wherein formulating further comprises adding a hydrocarbon mixture having a concentration of between one parts per million to 10% by weight to the polymer.

7. The method of claim 6 wherein formulating further comprises adding a hydrocarbon mixture having a concentration of between one parts per million to 5% by weight to the polymer.

8. The method of claim 6 wherein formulating a first mixture of a polymer further comprises formulating a first mixture of an olefinic polymer and a hydrocarbon mixture.

9. The method of claim 1 wherein thermoforming the substantially planar sheet to form the polymeric part further comprises heating the mold to at least 140°F.

10. The method of claim 1 wherein thermoforming the substantially planar sheet to form the polymeric part further comprises exposing the planar sheet and forming mold to a temperature of at least 750°F for at least 40 seconds..

11. A method for creating a polymeric part having an anti-graffiti property, the method comprising:

mixing a first compound of a polymer and a hydrocarbon mixture;

mixing a second compound of a mineral oil and wax;

extruding the first compound of polymer and hydrocarbon mixture into a substantially planar sheet;

coating a surface of a mold with the second compound of mineral oil and wax;

applying a polyester film to the planar sheet; and

thermoforming the planar sheet to form the polymeric part using the mold coated with the second compound of mineral oil and wax mixture.

12. The method of claim 11 wherein formulating a first compound further includes mixing a mineral oil and a wax to form the hydrocarbon mixture.

13. The method of claim 11 wherein mixing the second compound includes mixing 50% mineral oil and 50% wax by weight to form the second compound.

14. The method of claim 11 wherein the hydrocarbon mixture has a melting point between 25-65°C.

15. The method of claim 14 wherein the hydrocarbon mixture has a melting point between 35-50°C.

16. The method of claim 11 wherein mixing a first compound further comprises adding a hydrocarbon mixture having a concentration of between one parts per million to 10% by weight to the polymer.

17. The method of claim 16 wherein mixing a first compound further comprises adding a hydrocarbon mixture having a concentration of between one parts per million to 5% by weight to the polymer.

18. The method of claim 16 wherein mixing a first compound of a polymer further comprises mixing a first compound of an olefinic polymer and a hydrocarbon mixture.

19. The method of claim 18 wherein thermoforming the substantially planar sheet to form the polymeric part further comprises heating the mold to at least 140°F.

20. The method of claim 18 wherein thermoforming the polymeric part further comprises exposing the planar sheet and mold to a temperature of at least 750°F for at least 40 seconds.

21. A polymeric part having an anti-graffiti property, the part comprising:
a first mixture of a polymer and a hydrocarbon mixture wherein the first mixture is formed into a substantially planar sheet and thermoformed using a forming mold coated with a second mixture of mineral oil and wax.

22. The polymeric part of claim 21 wherein hydrocarbon mixture is mixture of a mineral oil and a wax.

23. The polymeric part of claim 21 wherein the hydrocarbon mixture has a melting point between 35-50°C.

24. The polymeric part of claim 21 wherein the hydrocarbon mixture has a concentration of between one parts per million to 10% by weight to the polymer.

25. The polymeric part of claim 21 wherein the polymer is an olefinic polymer.

26. The polymeric part of claim 21 wherein the second mixture is a mixture of 50% mineral oil and 50% wax by weight.

27. The polymeric part of claim 21 further comprising first layer comprised of the first mixture and a second layer comprised of polyester.